

Work Order ID 68007

Tuesday, April 05, 2011 10:52:15 AM



Page 1

Item ID: D4323-20
Revision ID: PRELIM
Item Name: Cabin Side Post, RH

Accept



Setup Start



Stop



Start Date: 4/5/2011 Start Qty: 1.00
Required Date: 4/5/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

~~PRELIMINARY ISSUE~~

Reference:

Approvals: Process Plan: NLF Date: 11-04-05 Tooling:
QC: Date: SPC (Y/N):

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4323	PA1 PA6 <u>11/04/07</u> <u>ADJ</u>

100	HandThermo	Memo	0.00
	Hand Finishing Thermoforming	1-Cut Sheet to required Blank size	

1

DL
11/04/07

105	HandThermo	Memo	0.00
	Hand Finishing Thermoforming	Dry Sheet as per QSI022 KYDEX	

Dry Material

Temp: 150°F
Time IN: 4:30 pm
Time OUT: 6:00 am

11/04/07
11/04/07

DL
11/04/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Stop



Item Name: Cabin Side Post, RH

Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA102 using tool DT9728
Dwg Rev: PA8
Folio Rev: A

DL
11/04/07

120

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

DL
11/04/07

130

0.00



QC

Memo

0.00

Quality Control

QC8- Inspect parts - second check

Parts sent entomex
S. Alarcon

BB
11/04/07

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Page 3

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Required Date: 4/5/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

N/A

PTO →
LAST Page.

150

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Complete FAI document

u

160

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Page 4

Item ID: D4323-20

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Setup Start

Revision ID: PRELIM

Stop

Item Name: Cabin Side Post, RH

Start Date: 4/5/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 4/5/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

10/16/04

0.00

Packaging

11/14/12

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/12
11-0407
202370

POSITIVE RECALL

EFFECTIVE

11/05/05

AUTH

11

RELEASED

11/05/13

DATE

11/05/13

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:52:13 AM

Page 1

Work Order ID: 68007



Parent Item: D4323-20



Parent Item Name: Cabin Side Post, RH

Start Date: 4/5/2011

Required Date: 4/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue 11/03/22 DL verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	787.2912	13.5416	14.25432			



6185 KYDEX .080"



Location

therm

Loc Qty

787.2912

Loc Code

787.2912

116576

38.50 sq ft. 11/04/07

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 68007
Description:	Part Number: D4323-20
Inspection Dwg: 04323 Rev: AAB	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>SK</u>	Date: <u>11/04/07</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<u>0.040"</u>	<u>M.N.</u>	<u>0.030"</u>				<u>See e-mail</u>

Measured by: <u>SK</u>	Date: <u>11/04/07</u>
Audited by: <u>S Part sent witness</u>	Date: <u>11/04/07</u>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10-04-14

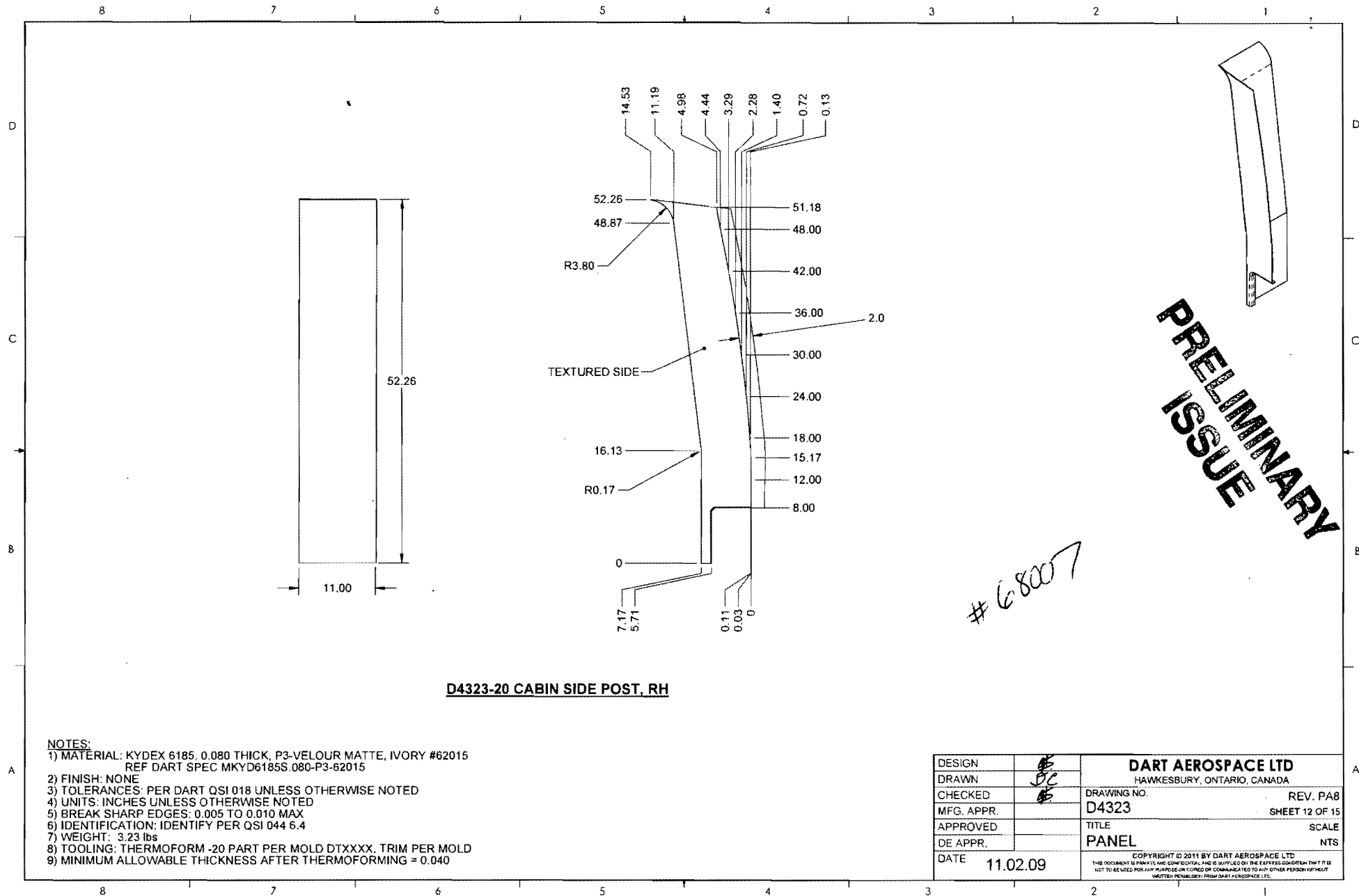
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Monday, April 04, 2011 9:16 AM
To: 'Daryl Leger'
Cc: 'JEANLUC MENARD'; Bill Beckett; 'Linda Lacelle'; 'Harvey Siemens'; 'Mike Petsche'
Subject: D4323 & D4380 - Parts can be untrimmed

To Whom It May Concern,

The parts with p/n's D4323-XX and D4380-XX can be shipped to Calgary untrimmed, or even slightly out of spec in order to get parts here asap so they can be installed on the Westpac machine.

Thanks,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Daryl Leger

From: Daniel Campbell <dcampbell@dartaero.com>
Sent: Friday, April 01, 2011 4:22 PM
To: Eric Charbonneau
Cc: 'Daryl Leger'; 'Jean-Luc Menard'; 'Linda Lacelle'; Bill Beckett; 'Harvey Siemens'
Subject: D4323 Parts

Hi Eric,

I have put D4323-PA7 in the Prelim folder.

I have also created dxfs for the -23/-25 although I'm not sure if you need them since these parts will need to be thermoformed to obtain the finished/beveled/tapered edge. I didn't create a dxf for the -24 because it is the same outline as the -23, but finished edge is on the opposite side for the -24. (Please call me if I'm confusing you on this.)

We need another set of the D4323-19/-20 cabin posts. The -19 is too narrow – I have added 2.0" to it. It can be left untrimmed and the guys here will trim it to fit the aircraft exterior. We also need another -20 since the one that arrived yesterday (Mar. 31) was damaged.

I have also modeled and drawn up the remaining kydex parts -23/-24/-25.

Here's the list:

Qty	P/N	Description	Notes
1	D4323-19	Cabin Side Post, LH	Pls leave the part untrimmed by at least 2.0" inches as indicated in the drawing.
1	D4323-20	Cabin Side Post, LH	Pls leave the part untrimmed by at least 2.0" inches as indicated in the drawing.
1	D4323-23	Access Panel, LH	New part – requires a finished/beveled/tapered edge as indicated
1	D4323-24	Access Panel, RH	New part – requires a finished/beveled/tapered edge as indicated
1	D4323-25	Panel, Glove Box	New part – requires a finished/beveled/tapered edge as indicated

Cheers,

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

Dart Aerospace Ltd

W/O: 68007		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/04/07	140	PARTS NOT TRIMMED. Customer will trim to fit as per attached e-mail.	Wb.	11/04/07	1		

Part No: D4323-20 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

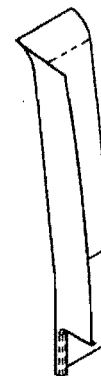
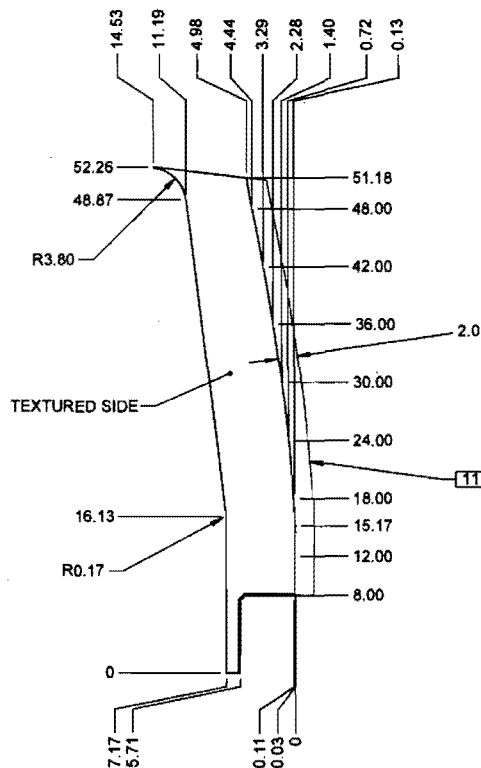
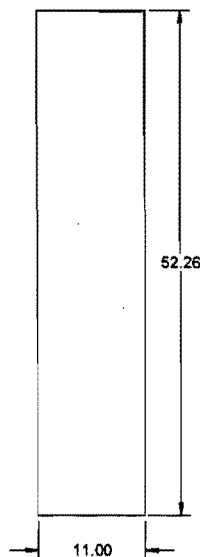
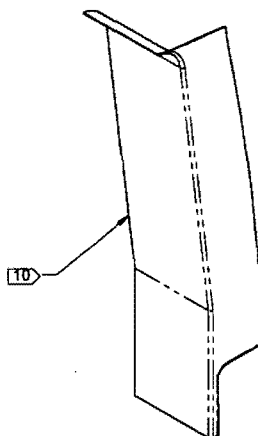
C

B

D

C

B



D4323-20 CABIN SIDE POST, RH

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 3.23 lbs
- 8) TOOLING: THERMOFORM PER MOULD DT9728 AND DART QSI 022. TRIM PER MOULD
- 9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040 EXCEPT AS INDICATED
- 10) MINIMUM ALLOWABLE THICKNESS ALONG THIS EDGE = 0.015
- 11) LEAVE 2.00 INCH UNTRIMMED EDGE

68007

RELEASED
2011-05-10

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4323	SHEET 12 OF 15
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	11.04.21	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

